

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001606**Date Inspected:** 22-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Ming Kai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 7 OBG:

The QA Inspector randomly observed ZPMC Welder Wang Linjiang ID Number 051356, utilizing the Flux Cored Arc Welding (FCAW) Process with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2132-3 in the 2F (Horizontal Fillet) position, to tack weld various stiffeners and flange piece mark X7M during fit up, to Floor Beam Sub-Assembly FB025-01. The QA Inspector randomly observed ZPMC CWI Wu Ming Kai monitoring weld parameters. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC Welder Hong Shuli ID Number 044815, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2132-3 in the 2F (Horizontal Fillet) position, to tack weld various stiffeners during fit up on Floor Beam Sub-Assembly FB018-02. The QA Inspector randomly observed ZPMC CWI Cui Yi Ru monitoring weld parameters.

The QA Inspector randomly observed ZPMC Welder Zhang Qing Quan ID Number 044774, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2132-3 in the 2F position and WPS WPS-B-T-2133 in the 3F position, to tack weld the flange to Floor Beam Diaphragm FB004-01 at Weld Joint (WJ) FB004-01-027/028. The QA Inspector randomly observed ZPMC CWI Cui Yi Ru monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 276 amps, 29.2 volts. Travel speed was not

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## WELDING INSPECTION REPORT

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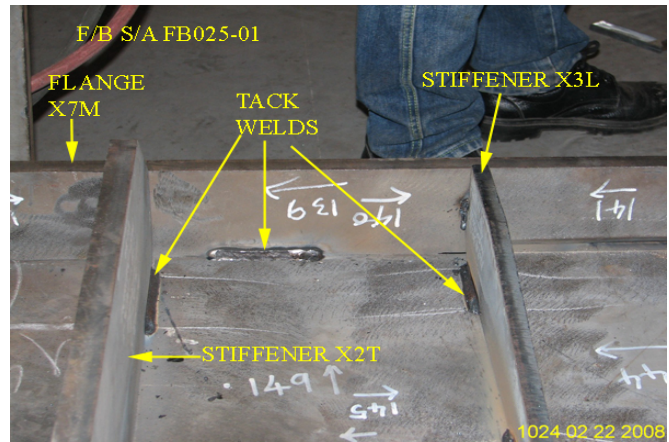
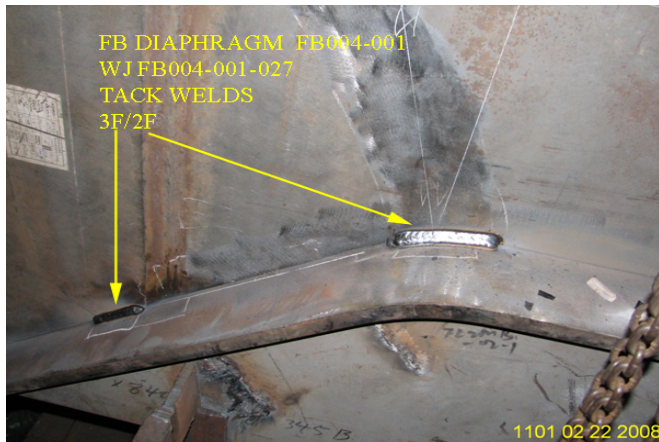
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monitored. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC Welder Hong Yongli ID Number 044801, utilizing the FCAW Process with ZPMC WPS WPS-345-FCAW-2G(2F)-FCM Repair to weld first time repairs on Floor Beam Web FB015-02 WJ FB015-02-015 area 99 and FB007-05 WJ FB007-05-003 area 70. The QA Inspector randomly observed ZPMC CWI Zhang Zhong monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 292 amps, 30.5 volts with a travel speed of 320 millimeters per minute.

Bay 8:

The QA Inspector randomly observed ZPMC Personnel performing heat straightening operations per ZPMC HSR1(T)-039 piece mark 28M BTM p249(N).



### Summary of Conversations:

There were no relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Franco,Charlie	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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